

Work Order ID 70295

Thursday, June 02, 2011 1:43:50 PM

Page 1

Item ID: D2012-105

Accept

Revision ID:

Item Name: Arm

Start Date: 6/9/2011 Start Qty: 5.00

Required Date: 6/16/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2012-105	E

100 0.00



Brake NC

Brake NC

NC BRAKE

Memo

Punch to length as per Dwg D2012-105 & template D2012-105T1

cut at 32.140

SB 11/06/14

110 0.00



Small Fab

Small Fab

Small Fab

Memo

I-Debur

0.00

SB 11/06/14 (5)

120 0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

SB 11/06/15

(+5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15
320
10:45

0.00

Sx of M-11/06/16

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

5 of 11 11/06/16

150

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

11/16/16 SLD

W/O:		WORK ORDER CHANGES						
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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/6/16 JF
MF
11-06-16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 1:43:47 PM

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Work Order ID: 70295



Parent Item: D2012-105

Parent Item Name: Arm

Start Date: 6/9/2011

Required Date: 6/16/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:1102.04.03 Added Inspect level 311NG11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	234.7796	2.6254	13.81789			
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

MAT017

234.779638

115535

2.33

116720

1.66068

117598

230.788958



86 11606/14

16

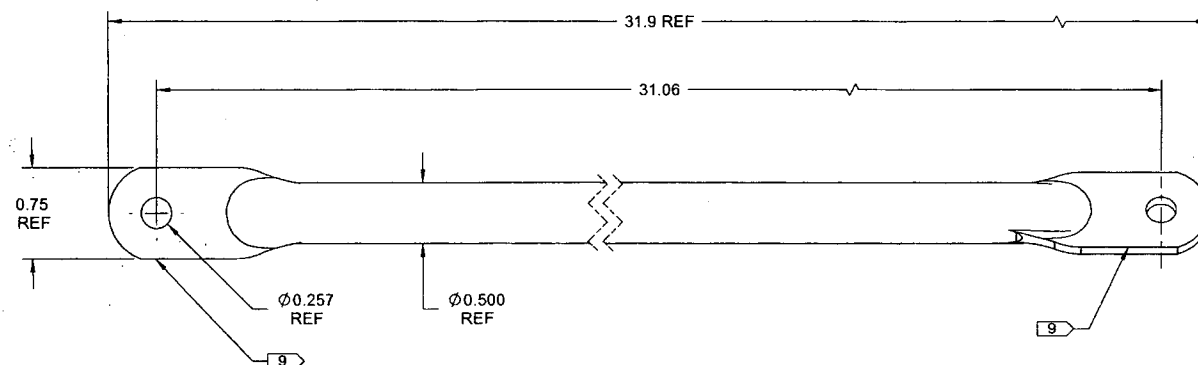
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NOTE: Date & initial all entries



D2012-105 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE Ø0.500 X 0.035 WALL PER ASME A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
- 7) WEIGHT: 0.47 lbs
- 8) MAKE PER TEMPLATE DT8116
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

RELEASED
8/18/25

REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG, ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-080	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	96.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2012-105 REV. E TITLE ARM SCALE NTS <small>COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB	DATE 09.06.04	

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